



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2512
Job Sheet 166001

SO10057



Part No: D2512

Job Qty: 1 ea

Part Name: Basket Lid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV H Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF IPP Rev:N 06.04.05 Added level21 EC IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified by:EC IPP Rev:R 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2512 Basket Lid	DWG REV H Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF IPP Rev:N 06.04.05 Added level21 EC IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified by:EC IPP Rev:R 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H DD VERF:JLM		0.000	
D2232-1 Basket Hinge	DWG REV C IPPB 01.06.07 Now laser cut EC IPP Rev:C Now on Waterjet 06-11-21 JLM		0.000	
D2236 Lid Rib	DWG REV C IPP REV:A 12.11.28 NEW ISSUE DD VERF:JLM		0.000	
D2506 Label Plate	DWG REV F IPP B 01.06.08 Now laser cut EC IPP C 06.12.13 ecn 822 ec IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:		0.000	
D2512-3 Rib	DWG REV H SHEET 4 IPP REV:A 12.07.27 AS PER DWG REV.F DD VERF:EC		0.000	
D2512-5 Rib	DWG REV H SHEET 4 IPP REV:A 12.07.27 AS PER DWG REV.F DD VERF:EC		0.000	
D2512-7 Rib	DWG REV H SHEET 4 IPP Rev:A New Issue 08-12-02 DD verified by:ec IPP Rev:B 11.01.31 chg qc5 to 6 DD verified by:ec		0.000	
D2581 Mounting Bracket	DWG REV A1 IPP D 01.07.17 Added info to step 2 S'			
D3825-043 Rib Assembly (Basket End, Lid)	DWG REV C IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC IPF AS PER DWG REV.C DD VERF:EC			
D3833-7 Mesh (Lid End)	DWG REV B IPP REV:A 12.07.27 AS PER DWG REV.B DD			
M304EX0.75-16F Expanded Metal Flat SS (D3832-13)				

Status: Stock

Part: **D2512 B166001**

Created: 9/30/17 11:47 AM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: **S000071**

Printed By: Goldston, Justin 10/2/17 10:44 AM

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/28/17	0.00	0.00	Start up container	
170	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	

21 NOV 1 12:53 PM Dart.Renwick.Jennifer
9-69

Part Op
Descriptions: 170 - ***INSTALL D2012-117 CLEVIS ONLY ON D130-701-041***

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D2512 B166001		1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2512 B166001	1	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/1/17 12:53 PM Dart.Renwick.Jennifer

Work Order Summary

Thursday, September 28, 2017 2:32:14 PM

Page 1 of 2

Criteria : Work Order ID: 166001 Item ID: D2512 Product Family LARGE FAB
Work Order Start Dates 9/14/2017 to 9/14/2017 11:59:59 PM Work Order Required Dates 9/20/2017 to 9/20/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID	166001	Required Qty	1.0000	Status Code	Released
Item ID	D2512	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Basket Lid				
Current Acct Value	\$1,876.231				

Start Date	9/14/2017	Required Date	9/20/2017	Completed Date	
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Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
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Direct Costs	Total	Each	Each	Each	Each
Material	\$240.335	\$0.000	\$239.564	\$239.564	100.00%
Labor	\$434.541	\$0.000	\$419.683	\$419.683	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$931.774	\$0.000	\$900.121	\$900.121	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,606.650	\$0.000	\$1,559.367	\$1,559.367	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D2232-1 Basket Hinge	2.0000		9/11/2017	2.0000	\$6.343
D2236 Lid Rib	4.0000		9/20/2017	4.0000	\$108.260
D2506 Label Plate	1.0000		9/11/2017	1.0000	\$14.085
D2512-3 Rib	2.0000		9/11/2017	2.0000	\$128.325
D2512-5 Rib	6.0000		9/11/2017	6.0000	\$81.539
D2512-7 Rib	3.0000		9/20/2017	3.0000	\$36.537
D2581 Mounting Bracket	2.0000		9/11/2017	2.0000	\$11.188
D3825-043 Rib Assembly (Basket End, Lid)	2.0000		9/11/2017	2.0000	\$124.873
D3833-7 Mesh (Lid End)	2.0000		9/11/2017	2.0000	\$27.576
M304EX0.75-16F Expanded Metal Flat SS	18.6000		9/20/2017	20.0000	\$84.000

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LAUG01												
	9/25/2017											
140			0.00	0.00	3.00	3.00	1.00	\$0.000	\$65.491	\$163.472	\$0.000	\$228.964
ROQU01												
	9/21/2017											
125			0.00	0.00	0.26	0.26	1.00	\$0.000	\$5.671	\$14.154	\$0.000	\$19.825
Total:			0.00	0.00	3.26	3.26	2.00	\$0.000	\$71.162	\$177.627	\$0.000	\$248.789

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
GAUT02												
	9/8/2017											
100			0.00	0.00	0.33	0.33	1.00	\$0.000	\$7.162	\$14.537	\$0.000	\$21.698
gauv01												
	9/14/2017											
100			0.00	0.00	1.46	1.46	1.00	\$0.000	\$31.330	\$63.592	\$0.000	\$94.922
100			0.00	0.00	3.55	3.55	1.00	\$0.000	\$76.241	\$154.752	\$0.000	\$230.993
	9/15/2017											
100			0.00	0.00	0.22	0.22	1.00	\$0.000	\$4.724	\$9.588	\$0.000	\$14.311
	9/19/2017											
100			0.00	0.00	0.55	0.55	1.00	\$0.000	\$11.771	\$23.893	\$0.000	\$35.664
100			0.00	0.00	0.90	0.90	1.00	\$0.000	\$19.391	\$39.359	\$0.000	\$58.750
100			0.00	0.00	0.75	0.75	1.00	\$0.000	\$16.054	\$32.586	\$0.000	\$48.640
	9/20/2017											
100			0.00	0.00	2.93	2.93	1.00	\$0.000	\$63.012	\$127.900	\$0.000	\$190.912
Total:			0.00	0.00	10.68	10.68	8.00	\$0.000	\$229.684	\$466.206	\$0.000	\$695.891

Work Center Powdercoat

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ROQU01												
	9/21/2017											
130			0.00	0.00	0.51	0.51	1.00	\$0.000	\$11.226	\$28.020	\$0.000	\$39.246
Total:			0.00	0.00	0.51	0.51	1.00	\$0.000	\$11.226	\$28.020	\$0.000	\$39.246

Work Order ID 166001

Thursday, September 07, 2017 11:11:30 AM

166001

Page 1

Item ID: D2512

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid

Start Date: 9/14/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/20/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: SEP 07 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2512

H

100

Weld per dwg A/R S.S. rod Batch: 4135068 0.00

Large Fab

100

Large Fab

Memo

3.29

/x DAS
43
9-89SEP 20 2017

1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436

2- Cut D3832-13 Lid Mesh.

3- WELD MESH AND REMOVE SECTIONS OF MESH WHERE
INDICATED AS PER DWG

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 17.9.21 PC

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
SEP 5 0 5017								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 2

Hand Finishing

1 17.9.21 PC

1 Ø 1709-21. DAS 54 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Work Order ID 166001

Thursday, September 07, 2017 11:11:30 AM

166001

Page 4

Item ID: D2512**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Basket Lid**Start Date:** 9/14/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/20/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.01

Quality Control

160

Identify as per dwg & Stock Location: wb

0.00

160

Packaging

Memo

0.01

Packaging

0130-701-041 / 13160944 h f all calced

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.10

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Thursday, September 07, 2017 11:11:29 AM

Work Order ID: 166001

166001

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 9/14/2017

Required Date: 9/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R
 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
 PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
 REV.G DD VERF:EC IPP REV:U 16.11.03 AS PER DWG REV.H
 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2232-1		Manufactured	No			100	Each	17.0000	2	2			
✓ *D2232-1*									**			2012-09-11	
Basket Hinge													

Location

Loc Qty

Loc Code

WA004

17

B156806

156805

17

B156805 → 2

D2236		Manufactured	No			100	Each	0.0000	4	4			
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✓ *D2236*

Lid Rib

B166002 → 4 ** 2017-09-11

D2506		Manufactured	No			100	Each	12.0000	1	1			
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✓ *D2506*

Label Plate

** 2017-09-11

Location

Loc Qty

Loc Code

WA004

12

B157613 → 1

157613

2

164115

5

164261

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Picklist Print

Thursday, September 07, 2017 11:11:29 AM

Page 2

Work Order ID: 166001

166001

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 9/14/2017

Required Date: 9/20/2017

Start Qty: 1.00

Required Qty: 1.00

D2512-3

Manufactured No

100

Each

12.0000

2

2

D2512-3

Rib

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

12

B157743 → 2

154032

1

157743

7

162962

4

D2512-5

Manufactured No

100

Each

12.0000

6

6

D2512-5

Rib

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

12

B157598 → 6

157598

12

D2512-7

Manufactured No

100

Each

3.0000

3

3

D2512-7

Rib

**

B166107 → 3

DAS
43
9-89

SEP 20 2017

Location

Loc Qty

Loc Code

WA004

3

157618

2

165802

1

D2581

Manufactured No

100

Each

46.0000

2

2

D2581

Mounting Bracket

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

46

B161800 → 2

161800

10

162923

8

164446

28

Thursday, September 07, 2017 11:11:30 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, September 07, 2017 11:11:30 AM

Page 3

Work Order ID: 166001

166001

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 9/14/2017

Required Date: 9/20/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-043

Manufactured No

100 Each 4.0000 2 2

D3825-043

Rib Assembly (Basket End, Lid)

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA004

4 B158872 → 2

158872

4

✓ D3833-7

Manufactured No

100 Each 6.0000 2 2

D3833-7

Mesh (Lid End)

**

DC 2017-09-11

Location

Loc Qty

Loc Code

WA006

6 B157604 2

157604

4

163739

2

M304EX0.75-16F

Purchased No

100 sf 610.9221 18.6 18.6

M304FX0 75-16F

Expanded Metal Flat SS

**

4138390 → 20x6 SEP 19 2017

Location

Loc Qty

Loc Code

WA004

610.9221052

M137765

9.29473684

M138128

121.627368

M138390

480

DAS
43
9-89

(D3832-13)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166001

SEP 07 2017

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 2
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

RELEASED

2016 NOV 02
EN 16-113 9

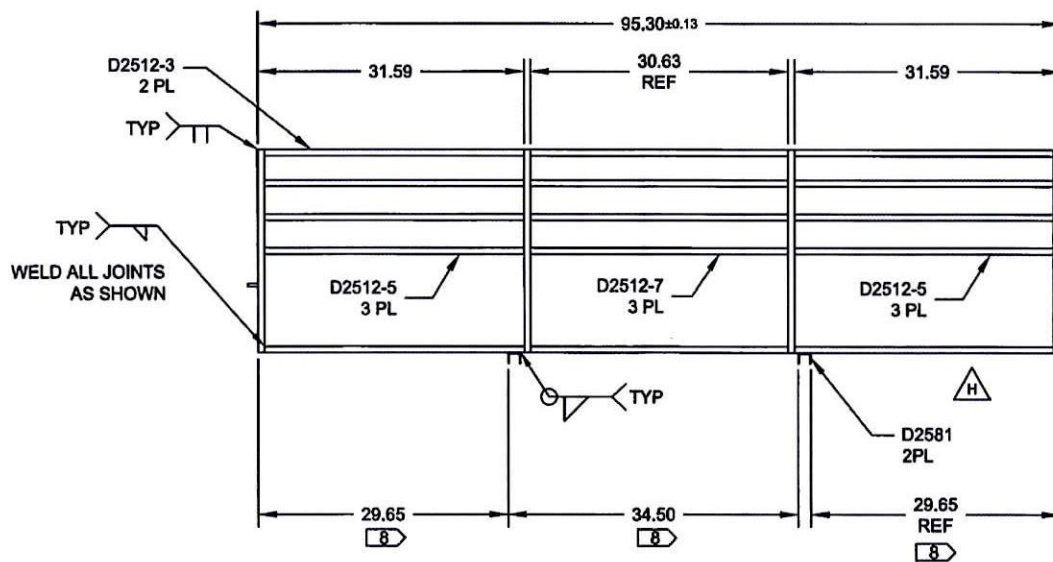
QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

H	REMOVED D2012-117 (ZN A8-2, C3-2)	VS	15.11.04
G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION: REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.08.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCOMP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	15.11.04	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

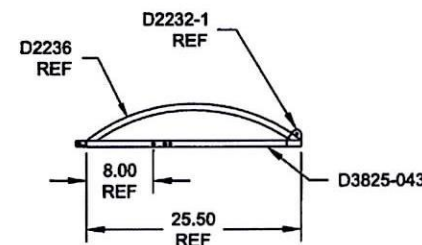
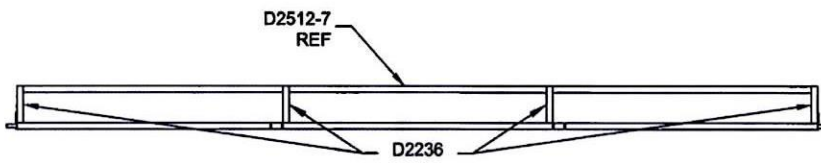
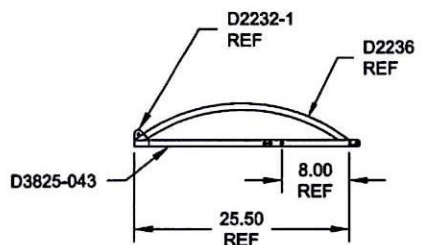
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

D3833-7
TYP, BOTH ENDS



DETAIL B D6-1
FRAMEWORK ONLY SHOWN FOR CLARITY

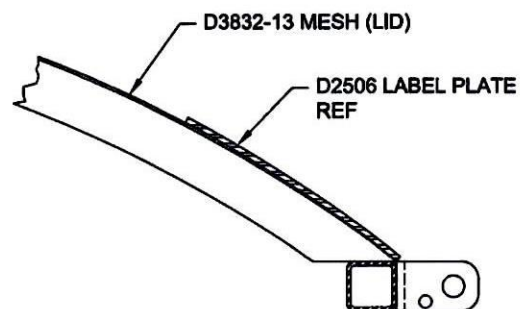


NOTES:

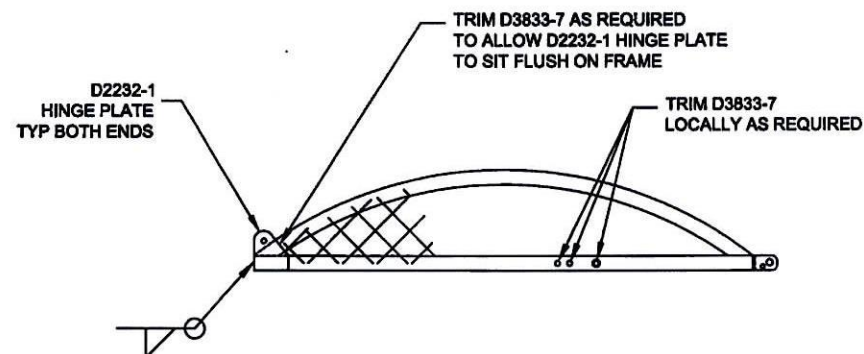
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY

RELEASED
2016 NOV 02

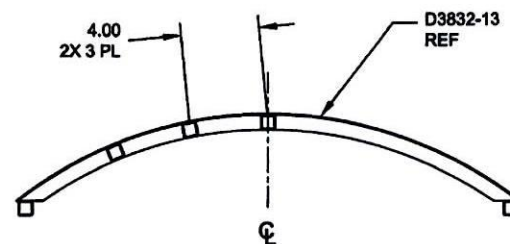
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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SECTION A-A
(ROTATED 90° CCW) C8-1



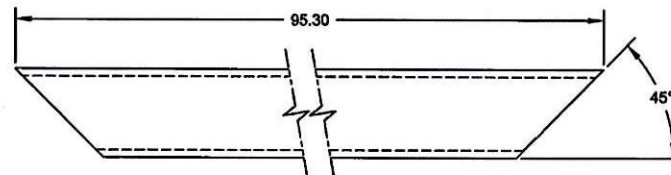
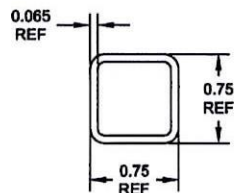
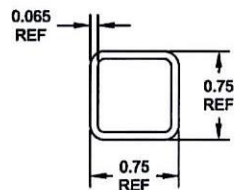
VIEW C-C SIMILAR BOTH END RIBS B8-1



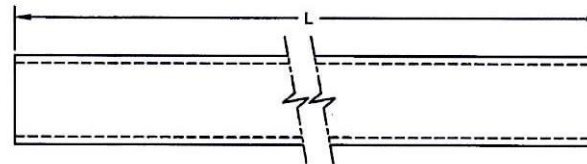
SECTION D-D SAME BOTH CENTER RIBS B7-1

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2016 NOV 02 4

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DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 3 OF 4
APPROVED	25	TITLE	SCALE
DE APPR.	31	BASKET LID ASSEMBLY (350/212)	NTS
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D2512-3 RIB 2x



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

36x
3x

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED

2016 NOV 02 4P

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. H
MFG. APPR.	DD	D2512	SHEET 4 OF 4
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	BASKET LID ASSEMBLY (350/212)	NTS
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